

Work Order ID 86754

July-06-12 2:17:03 PM

\*86754\*

Page 1

Item ID: D2322

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Step Spacer

Stop

\*NS2\*

Start Date: 7/06/12

Start Qty: 24.00

\*24\*

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 24.00

\*24\*

Customer:

Reference:

Approvals: Process Plan:

Date 12-07-9

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2322	Rev C

100 0.00

\*100\* FLOW WATER JET

Waterjet

Memo 0.00

FLOW CNC Waterjet

2024 . 040

1-Cut as per Dwg D2322 Dwg Rev: C Prog Rev: C 2-  
Deburr if necessary

12-7-24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

12-7-24

\*110\*

QC

Quality Control

Memo 0.00

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Quality Control

Memo 0.00

5mB  
12-7-25  
DAS  
16  
9-89  
110725

+26 →

took off +1 Part  
on inspection

W/O: 86754

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
17/07/25	# 120	Took Qtr+1 For QC inspection template	S	12/08/17	1x	DAS 12 89 12.08.17	DAS 16 89 17/07/25

Part No: D 2322 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

Work Order ID 86754

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Page 2

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Start Qty: 24.00

\*24\*

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 24.00

\*24\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

\*130\*

NC BRAKE

0.00

26

SB  
12/08/15

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D2322

140

\*140\*

QC5- Inspect part completeness to step on W/O

0.00

SB  
12/8/15 (DAS  
16  
0-89  
17/08/15)

26  
cont

QC

Quality Control

150

\*150\*

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

26 12/8/15

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID 86754

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\*86754\*

Page 3

Item ID: D2322

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Step Spacer

Stop

\*NS2\*

Start Date: 7/06/12 Start Qty: 24.00

\*24\*

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 24.00

\*24\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

\*160\*

QC

Quality Control

QC7-Inspect Chemical Conversion Coat

0.00

DAS  
16  
8-3

12/08/16

170

\*170\*

Packaging

Packaging

Identify as per dwg & Stock Location GA

0.00

✓

SL

12/08/16

180

\*180\*

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

MJ 12/08/17

MJ 12/08/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

July-06-12 2:17:03 PM

Page 1

Work Order ID: 86754

Parent Item: D2322

Parent Item Name: Step Spacer

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A New Issue 05-11-07 JLM  
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	178.1612	0.203	5.1284208			B12-7-24

Location	Loc Qty	Loc Code
MAT022	178.1611626	
120605	49.6627416	
121197	32.498421	
122136	96	122136

(27)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	PL754
Description: Step Spacer	Part Number:	D2322
Inspection Dwg: D2322	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	HB	Audited by:	SM/B 	Prototype Approval:	N/A
Date:	17-7-24	Date:	12-7-25 16:08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

**DART**

QA COPY ISSUED

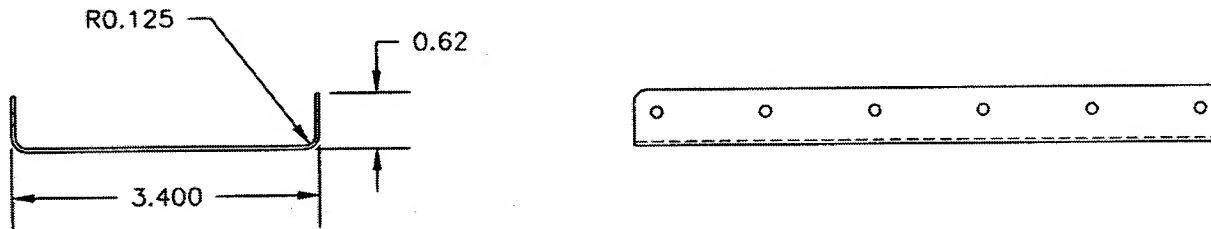
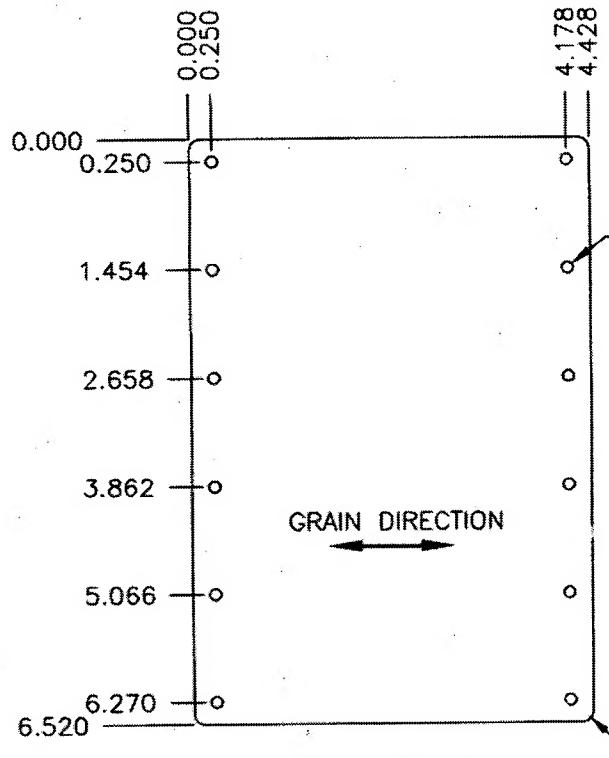
DESIGN BY	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2322
RE. C	REV. C	SHEET 1 OF 1
DATE	DATE	SCALE
98.09.29	98.10.14	1:2

**RELEASED****UNDER REVIEW**10/03/98 DS  
CPDESIGN AND BOR CHECK WITH  
DTS BEFORE MANUFACTURE

OK BY DTS

0.128 (TYP 12 PLACES)  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 76554

0.125  
(TYP 4 PLACES)  
KE 98.09.06



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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